Quality Control

Work Order II Thursday, February 2				*976	340*		···				Page 1
Item ID: D39 Revision ID:	13-041			Accept	*N900	040	100)* s	Setup Star	I Z	S1*
Item Name: Long	Basket B	ase Assemby, 350							Stop	, *N	S2*
Start Date: 2/21	/2013	Start Qty: 1.00	*1*		Cust Item I	D:					
Required Date: 2/28	/2013	Req'd Qty: 1.00	*1*		Customer:						
Reference:						<u>.</u>	_		S 64	4	
Approvals: Pro	cess Plar	n:	Date: 13-02	//Tooling:	Da	ate:		ŀ	Run Star	17	R1*
QC		/`	Date:	SPC (Y/N):	Da	ate:			Stop	` *N	R2*
Sequence ID/ Work Center ID		Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revi	sion Nbr									
D3913	В										
D4020	A	i 									
100		Weld per dwg A/R. S.S.	rod Batch: 122-	BF 0.00					11		
100 Large Fab		Large Fab Memo		0.00			(/x)		NY 13	3 - 03 :	0.4
Large Fab		l - assemble	ribs, weld as per dwg l before welding mesh***								
				weld all mesh on basket as p trim to clear fasteners hole							
			ge (3) and Mounting brack to locate hinge and brack								
		4- Weld D4	672-1 blanking plates as	per dwg							
110		QC9- Inspect visual per	QSI004- Fusion Welds	0.00							DAS:
*11 0 *		Memo		0.00	·				13-03-1	J/O	0AC 09
		Mamo		0.00							~

											DQA:	Date	:
NCR:	Yes	/ No				WORK ORDER NON-	COI	NFORN	ANCE / UP	DATE			
· · · · · · · · · · · · · · · · · · ·											QA Closed:	Date	:
Work Ord	or.					DISPOSITION				AGAINST DE	PARTMENT,	/PROCESS	
WOIK OIG	CI.					Rework	7		Skid-tube	Crosstube	I	Water Jet	Engineering
Part (No.					Scrap	1		Machining	Small Fab	Pro	d. Eng. Coor.	Quality
						Use-as-is	1		oforming	Finishing	Rec/Sto	re/Packaging	Other
NCR	No.					Work Order Update]		Large Fab	Composite]	Supplier	
							_	<u> </u>			,		
Root						ption of work order update	1	Initial		tion	Sign &		
Cause		Date	Step	Qty		or Non-conformance	Ch	nief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data	L												
Equip/Tooling													
Operator	<u> </u>												
Material	Ŀ												
Setup	L												
Other								ļ					
Process											ļ		
Supplier													Ì
Training													
Unapproved										<u> </u>	<u> </u>		
						F	AUI	T CATE	GORY				
Landi	ng (Gear				General	_	,		_	7	_	 1
		Bending				Bend		Grain			Ovalized		Pressure/Forced
	L	Centre No	ot Concer	ntric to	o/s	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure
		Cracks				Broken/Damaged	L	Inspecti	on Incomplete		Part Incorre	ct	Weld
		Crushed/	Crimped.			Burrs		Instruct	ions Incomplete/	Unclear	Part Lost/M	issing	Wrong Stock Pulled
		Cuffs				Contamination	L	Mainte	nance		Part Moved		
		Heat Trea	it			Countersink		Mislabe	led		Positioned \	Wrong	
		Inspectio	n Strip in	Tube		Cut Too Short		Misread			Power Loss/	'Surge	Other
	OC	Ripples in	Bend			Drill Holes		Offset					

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Ord Thursday, Febr		7640 3 10:22:06 AM		*976	340*							Page 2
Item ID: Revision ID:	D3913-041			Accept	*N900	040	100) * s	Setup		*N:	S1*
Item Name:	Long Basket	Base Assemby, 350								Stop	*N:	S2*
Start Date: Required Date: Reference:	2/21/2013 : 2/28/2013	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item 1 Customer:	ID:						
Approvals:	Process Pl	an:	Date:	Tooling:	D	ate:	_	F	Run	Start	*N	R1*
	QC:		Date:	_ SPC (Y/N):		ate:				Stop	*N	R2*
Sequence ID/ Work Center I	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reje Qty		Reject Number	Insp. Stamp
120		QC5- Inspect part compl	eteness to step on W/O	0.00								* Q12
120 QC Quality Control		Memo		0.00					13-	<u>6</u> 3-C	ok.	09
									,	,		1 .
125		Pressure Wash per QS10	05 4.3	0.00				111	/ 4		/ ,	1/20/2
125 HandFinish		Memo		0.00				1 X D	1	11-6	- 13	103/2

Hand Finishing

NCR:	Yes	/ No				WORK ORDER NON-O	COI	VFORM	/IANCE / UPDA				•
											QA Closed:	Date:	
Work Ord	er:					DISPOSITION				AGAINST DE	PARTMENT	PROCESS	
Part I	- No		***************************************			Rework Scrap Use-as-is Work Order Update		1 Therm	Machining S	Crosstube Small Fab Finishing omposite		Water Jet d. Eng. Coor. e/Packaging Supplier	Engineering Quality Other
Root					Descri	ption of work order update	П	nitial	Action		Sign &		
Cause		Date	Step	Qty	(or Non-conformance	Ch	ief Eng	Descripti	on	Date	Verification	QC Inspector
Doc/Data													
Equip/Tooling													
Operator			ļ				İ						
Material												·	
Setup													
Other													
Process				· .									
Supplier													
Training]						
Unapproved				<u> </u>			1						
						F	AUL	T CATE	GORY				
Landi	ng G	iear				General					,		7
	-	Bending				Bend	_	Grain			Ovalized	<u> </u>	Pressure/Forced
	Ш	Centre No	ot Concer	ntric to	o/s	BOM/Route	_	Hardwa	re		Over/Under		Temperature/Cure
	Ш	Cracks				Broken/Damaged		4 '	on Incomplete		Part Incorred	├	Weld
	Ш	Crushed/	Crimped.		L	Burrs	<u></u>	4	ions Incomplete/Uncl	ear	Part Lost/Mi	ssing	Wrong Stock Pulled
	Ш	Cuffs				Contamination	_	Mainte			Part Moved		
	Ш	Heat Trea	it		_	Countersink	L	Mislabe			Positioned V		٦
	Ш	Inspection	n Strip in	Tube		Cut Too Short	L	Misread	I		Power Loss/	Surge	Other
		Ripples in	Bend			Drill Holes		Offset					·
		Torque W	aves in E	xtrusio	n [_	Drawing		Out of 0	Calibration				

Out of Sequence
Outside Dimensions

Date:

DQA:

Turning Sequence

Wave/Twist in Tube

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Ord Thursday, Febr		'640 3 10:22:06 AM		*976	40*						Page 3
Item ID: Revision ID: Item Name:	D3913-041 Long Basket	Base Assemby, 350		Accept	*N90004	ເ <u>ດ</u> 1ດດ)*	Setup	Start Stop	*N.9	===== 31* 32*
Start Date: Required Date Reference:	2/21/2013	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item ID: Customer:					ı d.	12
Approvals:	Process Pl QC:	an:	.		Date:			Run	Start Stop	*NF	₹1* ₹2*
Sequence ID/ Work Center 130 *130* Powdercoat Powder Coating		coat IST COAT START TIN OVEN TEN FINISH TIN *********** 2ND COAT START TIN	es and mask only interior of the state of th	Set Up/ Run Hours 0.00 0.00 of hinge (3) prior to powder ccessary***********************************		ol # Plan Code	Accept Qty	Qty	y N	Reject Number	Insp. Stamp
140 *140* QC Quality Control		QC3- Inspect Part Finisl Memo	0	0.00				Ø	13.	3-22	253

NCR:	Yes	/	No

											DQA:	Date	•
NCR:	Yes	/ No				WORK ORDER NON-	CO	NFORI	MANCE / UP	DATE			
											QA Closed:	Date	:
Nork Ord	er.					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
	•					Rework Scrap	-		Skid-tube Machining	Crosstube Small Fab	Pro	Water Jet d. Eng. Coor.	Engineering Quality
Part	NO.	· · · · · · · · · · · · · · · · · · ·				Use-as-is	\dashv		noforming	Finishing	-	re/Packaging	Other
NCR	No.					Work Order Update		9	Large Fab	Composite]	Supplier	
Root				D	escri	ption of work order update		Initial	Ac	tion	Sign &		
Cause		Date	Step	Qty	,	or Non-conformance	Cł	nief Eng	Desc	ription	Date	Verification	QC Inspector
oc/Data	Ш												
quip/Tooling		1											
perator													
1aterial													
etup													
ther													
rocess													
upplier													
raining													
napproved												<u>L</u>	
		···					FAUI	T CATE	GORY				
Landi	_	ī			_	General	_	7			7		¬_ ,_ ,
		Bending			_	Bend	\vdash	Grain		<u></u>	Ovalized		Pressure/Forced
			t Concer	ntric to O/S	\vdash	BOM/Route	-	Hardwa		-	Over/Under	<u></u>	Temperature/Cure
		Cracks			_	Broken/Damaged	-	4	on Incomplete	–	Part Incorre	 	Weld
une >		Crushed/0	Crimped.		\perp	Burrs	\perp	4	ions Incomplete/	'Unclear	Part Lost/M	issing	Wrong Stock Pulled
		Cuffs			<u> </u>	Contamination		Mainte		<u> </u>	Part Moved		
		Heat Trea			<u> </u>	Countersink	<u> </u>	Mislabe		<u> </u>	Positioned \		¬
•		Inspection	•	Tube		Cut Too Short	<u> </u>	Misread	i	. <u>L</u>	Power Loss/	Surge	Other
		Ripples in	Bend		L	Drill Holes		Offset			. ———		· · · · · · · · · · · · · · · · · · ·
		Torque W	aves in E	xtrusion	L	Drawing	_	Out of	Calibration				
		Turning Se	equence			Finish		Out of 9	Sequence				

Outside Dimensions

Wave/Twist in Tube

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

•												
Work Orde Thursday, Febru				*976	340*							Page 4
Item ID: Revision ID: Item Name:	D3913-041	Base Assemby, 350		Accept	*N900	040	100)*	Setup St			31* 32*
	2/21/2013	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item I Customer:	D:					IU	17
Approvals:		an:				ate:				on		R1*
Sequence ID/ Work Center II 150 *150* HandFinish Hand Finishing	D	Operation Description Assemble as per dwg Memo Pick Kit		Set Up/ Run Hours 0.00	Tool ID	Tool#	Plan Code	Accept Qty	Qty	Nui	nber	Insp. Stamp
*160 *160*		QC5- Inspect part compl	eteness to step on W/O	0.00 0.00 6 13 (u	3/26							

170

Identify as per dwg & Stock Location: D40 30 - 6641

97646

170 Packaging

Quality Control

Memo

1 6 113-3-22

Packaging

0.00

NCR:	Yes	/ No				WORK ORDER NON-C	100	NFORM	/IANCE / UP	DATE					
												QA Closed:	Da	te:	
Work Ord	or.					DISPOSITION				AGAINST D	EΙ	PARTMENT	PROCESS		
Part f	No.					Rework Scrap Use-as-is		Therm	Skid-tube Machining Moforming	Crosstube Small Fab Finishing			Water Jet d. Eng. Coor. re/Packaging		Engineering Quality Other
NCR 1	No.		<u> </u>		 .	Work Order Update]		Large Fab	Composite			Supplier		
Root					Descri	ption of work order update		Initial	Ac	tion		Sign &			
Cause		Date	Step	Qty	C	or Non-conformance	Cr	nief Eng	Desc	ription		Date	Verificatio	n_	QC Inspector
Doc/Data															
Equip/Tooling															
Operator							1								
Material			İ												
Setup															
Other															
Process															
Supplier															
Training															
Unapproved		<u> </u>	<u> </u>									<u> </u>			<u>L</u>
							AUI	LT CATE	GORY						
Landi	ng (7				General	_	٦		Г		1		_]_
	<u> </u>	Bending				Bend	<u></u>	Grain		-		Ovalized		<u> </u>	Pressure/Forced
ļ		Centre No	ot Concer	ntric to (O/S	BOM/Route	\vdash	Hardwa		Ļ		Over/Under		<u> </u>	Temperature/Cure
		Cracks			<u> </u>	Broken/Damaged		- 1	on Incomplete	-		Part Incorre		\vdash	Weld
		Crushed/	Crimped.			Burrs		-	ions Incomplete	/Unclear		Part Lost/M	ssing	$ldsymbol{ldsymbol{ldsymbol{ldsymbol{ldsymbol{L}}}}$	Wrong Stock Pulled
		Cuffs				Contamination	_	Mainte		ļ		Part Moved			
		Heat Trea	ıt			Countersink		Mislabe	led			Positioned \	_	_	7
1		Inspectio	n Strip in	Tube		Cut Too Short		Misread	i			Power Loss/	Surge		Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

DQA:

Date:

Turning Sequence Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Orde Thursday, Febru				*976	340*							Page	5
Revision ID:	D3913-041 Long Basket l	Base Assemby, 350		Accept	*N900	<u>0</u> 40	100)*	Setup	Start Stop		S1* S2*	
Start Date: Required Date: Reference:	2/21/2013 2/28/2013	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item I Customer:	D:							
Approvals:	Process Pla	nn:	Date:	Tooling: SPC (Y/N):		ate:			Run	Start Stop	*N *N	R1* R2*	
Sequence ID/ Work Center II 180 *180* QC)	Operation Description QC21- Final Inspection	Work Order Release	Set Up/ Run Hours 0.00	Tool ID	Tool#	Plan Code	Accept Qty	Re Qt	•	Reject Number	Insp. Stamp	

MF 3-3-26

NCR:	Yes /	No				WORK ORDER NON-O	100	NFORN	AANCE / UPDATE				
											QA Closed:	Date	2:
Work Orde	or:					DISPOSITION			AGAINST	T DE	PARTMENT	/PROCESS	
WORK OIG	ei. —		····			Rework	1		Skid-tube Crosstube]	Water Jet	Engineering
Part N	۸o					Scrap			Machining Small Fat	—	-	d. Eng. Coor.	Quality
NCR I	No					Use-as-is Work Order Update			oforming Finishing Large Fab Composite		Rec/Sto	re/Packaging Supplier	Other
Root						ption of work order update	1	nitial	Action		Sign &		
Cause		Date	Step	Qty	C	or Non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector
Doc/Data													
Equip/Tooling	Ш												
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Process	\mathbf{H}												
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Unapproved	LL_			<u> </u>		F	<u> </u> Δ111	T CATE	GORY		<u> </u>	<u> </u>	
Landi	ng Gea	ar				General							· · · · · · · · · · · · · · · · · · ·
20.10		ending				Bend	Г	Grain		Г	Ovalized	Γ	Pressure/Forced
	—	_	t Concer	ntric to (o/s	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure
	\vdash	acks				Broken/Damaged		4	on Incomplete		Part Incorre		Weld
	—		Crimped.			Burrs		4	ions Incomplete/Unclear	\vdash	Part Lost/M	issing	Wrong Stock Pulled
	_	uffs	•			Contamination		Mainte			Part Moved	_	_
	Н	eat Trea	t			Countersink		Mislabe	led		Positioned \	V rong	
	$oldsymbol{oldsymbol{ ext{H}}}$		Strip in	Tube		Cut Too Short		Misread	!		Power Loss,	′Surge	Other
	_	pples in				Drill Holes		Offset		-			
	To	orque W	aves in E	xtrusio	,	Drawing		Out of C	Calibration				

Out of Sequence

Outside Dimensions

DQA:

Date:

Turning Sequence

Wave/Twist in Tube

Finish Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Picklist Print Thursday, February	21, 2013 10:22:1	l AM											Page 1
Work Order ID: 97	640		*(97640)*								Q
Parent Item: D3	913-041		_		3-041*								
Parent Item Name:	Long Basket Base A	Assemby, 350	•	17. 1.7. 1.	. ,-(,-+ 1				tart Date: 2/23 Start Qty: 1.00		_	d Date: 2/2 ed Qty: 1.0	
Comments:	IPP Rev:A new iss chg qty's DD 10.04 AS PER DWG REV	4.12 verified by:E	C		IPP Re PP REV:C 12.0								
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2581		Manufactured	No			100	Each	66.0000	2	2			
D2581 Mounting Bracket									** 1	3928	∄/→ J	x S	113-00
				Locatio	<u>n</u>	Loc	<u>Oty</u>	Loc Code					
				WA004			66		_		-		
					70766		2		_		-		
					81253 82506		1		_		-		
					83230		3		_		_		
					85452		2		_		 -		
					87706		2		_		<u>-</u>		
					88574		8		_		-		
					92871		20		_	 -	-		
D2012 1			N		94204	100	26 Eh	7.0000	1				
D3913-1		Manufactured	No			100	Each	7.0000		1		0.1	
*D3913-1	*								** =	B <i>88</i>	6 <i>3</i> 8 ,	SY 1	3-02.2
				<u>Locatio</u>	<u>n</u>	<u>Loc</u>	<u>Qty</u>	Loc Code					
				WA			2		****		_		
					87541		2		_		-		
				WA004			4		_		_		

WA005

										DQA:	Date	
NCR:	res / No				WORK ORDER NON-O	100	NFORI\	ANCE / UP	DATE			,
										QA Closed:	Date	•
Work Orde	~~.				DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
WOLK OLG	۶۱. <u></u>				Rework	1		Skid-tube	Crosstube	7	Water Jet	Engineering
Part N	No				Scrap	1	ľ	Machining	Small Fab		d. Eng. Coor.	Quality
NCR N	No				Use-as-is Work Order Update			oforming Large Fab	Finishing Composite	Rec/Sto	re/Packaging Supplier	Other
Root				Descri	ption of work order update		Initial	Ac	tion	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Ch	nief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data												
Equip/Tooling											,	
Operator												
Material		•										
Setup												
Other												
Process			.									
Supplier						İ						
Training												
Unapproved		<u> </u>				<u></u>				1	<u>l</u>	
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Landi	ng Gear				General		1		_	- 1	_	¬
	Bending			<u> </u>	Bend		Grain		_	Ovalized	_	Pressure/Forced
	Centre N	ot Conce	ntric to (D/S	BOM/Route		Hardwa		<u></u>	Over/Under	 -	Temperature/Cure
	Cracks			<u> </u>	Broken/Damaged		- 1 '	on Incomplete	<u> </u>	Part Incorre	⊢	Weld
		Crimped.	-	<u> </u>	Burrs	_	-1	ions Incomplete/	Unclear	Part Lost/M	- <u>-</u>	Wrong Stock Pulled
ļ	Cuffs				Contamination	_	Mainte		<u></u>	Part Moved		
	Heat Tre				Countersink	<u></u>	Mislabe		<u></u>	Positioned '		
	Inspection	n Strip in	Tube		Cut Too Short	<u></u>	Misread			Power Loss	/Surge	Other
	Ripples in	n Bend			Drill Holes		Offset					

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

 Location
 Loc Oty

 WA005
 8

 69160
 1

 84651
 1

94701 6 ______ 100 Each 21.0000 2 2

Loc Code

**

D3913-7 Manufactured No *D3913-7*

 Location
 Loc Oty
 Loc Code

 WA005
 21

 88492
 14

 95141
 7

Rib

B95141 -2x Sy13-00-28

												DQA:	Da	te:	e¥ su
NCR:	Yes	/ No				WORK ORDER NON-	COI	NFORM	MANCE / UPI	DATE					
												QA Closed:	Da	te:	
Work Ord	or.					DISPOSITION				AGAINST E	ÞΕΙ	PARTMENT	PROCESS		
Part N	-					Rework Scrap Use-as-is		ſ	Skid-tube Machining noforming	Crosstube Small Fab Finishing			Water Jet d. Eng. Coor. e/Packaging		Engineering Quality Other
NCR 1	No					Work Order Update]		Large Fab	Composite			Supplier	-	
Root					Descri	ption of work order update		Initial	Act	tion		Sign &			
Cause		Date	Step	Qty	(or Non-conformance	Ch	nief Eng	Descr	ription		Date	Verificatio	n	QC Inspector
Doc/Data															
Equip/Tooling															
Operator															
Material															
Setup												:		1	
Other															
Process															
Supplier															
Training															
Unapproved															
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Landi	ng G	ear				General	_	_							-
		Bending				Bend		Grain		L		Ovalized		L	Pressure/Forced
		Centre No	t Concer	ntric to	o/s	BOM/Route		Hardwa	re			Over/Under	tolerance		Temperature/Cure
		Cracks				Broken/Damaged		Inspecti	ion Incomplete	L		Part Incorred	ct		Weld
		Crushed/0	Crimped.			Burrs] Instruct	ions Incomplete/l	Jnclear [Part Lost/Mi	ssing		Wrong Stock Pulled
		Cuffs				Contamination		Mainte	nance	Γ		Part Moved			_
		Heat Trea	t			Countersink		Mislabe	led			Positioned V	Vrong		_
		Inspection	n Strip in	Tube		Cut Too Short		Misread	i	Ī		Power Loss/	Surge		Other

Offset

Out of Calibration
Out of Sequence

Outside Dimensions

Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drill Holes

Drawing

Finish Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Thursday, February 21, 2013 10:22:11 AM

Work Order ID: 97640 *97640* D3913-041 *D3913-041* Parent Item: Parent Item Name: Long Basket Base Assemby, 350 **Start Date: 2/21/2013** Required Date: 2/28/2013 Required Qty: 1.00 Start Qty: 1.00 D3913-9 100 6.0000 Manufactured Each 394512 NJ13-02-28 *D3913-9* Hinge Rib Loc Code Location Loc Qty WA005 70138 1 88215 94512 100 12.0000 2 2 D3916-041 Manufactured Each B 94093-22 - St 13.02-28 ** *D3916-041* Rib Assembly Location Loc Qty Loc Code WA 92672 6 WA005 2 81444 94093 D3916-5 100 Each 16.0000 Manufactured ** *D3916-5* Light Rib Loc Qty Loc Code Location WA004 11 94163 11 WA005 5 77142 82933

				-							DQ	A:	Date:	
NCR:	Yes	/ No				WORK ORDER NON-O	COI	NFORN	/IANCE / UP	DATE			_	
											QA Close	d:	Date:	
Work Ord	or.					DISPOSITION				AGAINST DE	PARTMEN	NT/PROCES	S	
WOIK OIG	E' . —					Rework	1		Skid-tube	Crosstube	1	Water	let	Engineering
Part I	No					Scrap Use-as-is		ľ	Machining noforming	Small Fab Finishing] P	rod. Eng. Co tore/Packag	oor.	Quality
NCR I	No					Work Order Update	_		Large Fab	Composite	, Kec/s	Supp		Other
Root					Descri	ption of work order update		Initial	Ac	tion	Sign &			
Cause		Date	Step	Qty	C	or Non-conformance	Ch	nief Eng	Desc	ription	Date	Verific	ation	QC Inspector
Doc/Data					• • • •									
Equip/Tooling								:			1			
Operator											İ			
Material														
Setup														
Other														
Process											1			
Supplier			i											
Training														
Unapproved													<u> </u>	
						F	AUL	LT CATE	GORY					
Landi	ng Ge	ar				General		-		_	-			-
,	ШВ	ending				Bend		Grain			Ovalized			Pressure/Forced
		entre No	ot Concer	ntric to (D/S	BOM/Route		Hardwa	re		Over/Und	ler tolerance	L	Temperature/Cure
		racks				Broken/Damaged	L	Inspecti	on Incomplete		Part Inco	rect		Weld
		rushed/	Crimped.			Burrs		Instruct	ions Incomplete	/Unclear	Part Lost,	'Missing		Wrong Stock Pulled
		uffs				Contamination		Mainte	nance		Part Mov	ed		
	∐⊦	leat Trea	t			Countersink		Mislabe	led		Positione	d Wrong		-
		nspection	n Strip in	Tube		Cut Too Short		Misread	I		Power Lo	ss/Surge		Other
	R	ipples in	Bend			Drill Holes		Offset						

Out of Calibration
Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

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Thursday, February 21, 2013 10:22:11 AM

97640 Work Order ID: 97640 Parent Item: D3913-041 *D3913-041* Parent Item Name: Long Basket Base Assemby, 350 **Start Date: 2/21/2013** Required Date: 2/28/2013 Required Qty: 1.00 Start Qty: 1.00 .D4016-1 Manufactured 100 Each 38.0000 B. 93117 SM 13-02-28 *D4016-1* Hinge Half, Base Loc Qty Location Loc Code WA005 38 93117 15 94481 23 100 Each 16.0000 D4017-7 Manufactured *D4017-7* Loc Oty Loc Code Location WA004 12 95102 12 WA005 69730 82969 85435 88392 15.0000 D4017-9 100 Each Manufactured No ** *D4017-9* Rib **Location** Loc Qty Loc Code WA005 15 2 70341 81445 89395 12

											DQA:	Date:	
NCR:	Yes	/ No				WORK ORDER NON-O	100	NFORM	ANCE / UPD	ATE	·		
											QA Closed:	Date:	
Work Orde	or:					DISPOSITION				AGAINST DE	PARTMENT,	/PROCESS	
WOIK OIG	ei					Rework	1		Skid-tube	Crosstube		Water Jet	Engineering
Part N	No.					Scrap			Machining	Small Fab	Pro	d. Eng. Coor.	Quality
	-					Use-as-is]	Therm	noforming	Finishing	Rec/Stor	re/Packaging	Other
NCR N	No					Work Order Update			Large Fab	Composite		Supplier	
Root	П				Descri	ption of work order update		Initial	Actio	on	Sign &		
Cause		Date	Step	Qty	(or Non-conformance	Ch	nief Eng	Descri	ption	Date	Verification	QC Inspector
Doc/Data	Ш												
Equip/Tooling	Ш				•								
Operator	Ш												
Material	Ш												
Setup	Ш												
Other	Ш		}								1		
Process	Ш			,									•
Supplier													
Training	Ш												
Unapproved							<u></u>						<u> </u>
						F	AUL	T CATE	GORY				
Landi	ng G	ear			_	General		3			٦	_	7
	Ш	Bending				Bend		Grain			Ovalized	_	Pressure/Forced
	Ш	Centre No	ot Concer	ntric to (o/s	BOM/Route	_	Hardwa	re	<u> </u>	Over/Under	<u> </u>	Temperature/Cure
	Ш	Cracks				Broken/Damaged		-	on Incomplete		Part Incorre	<u> </u>	Weld
	Ш	Crushed/	Crimped.			Burrs		-i	ions Incomplete/Ui	nclear	Part Lost/M	issing	Wrong Stock Pulled
		Cuffs				Contamination	_	Mainte	nance		Part Moved		
	Ш	Heat Trea	it			Countersink		Mislabe	led		Positioned \	_	¬
	\square	Inspection	n Strip in	Tube		Cut Too Short	L	Misreac	ł		Power Loss/	'Surge	Other
		Ripples in	Bend			Drill Holes		Offset					

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Picklist Print Thursday, February 21, 2013 10):22:11 AM							Page 5
Work Order ID: 97640		*97640*						<u> </u>
Parent Item: D3913-041		*D3913-	0/1*					·
	Base Assemby, 350	17.591.5-	()4		St	art Date:	2/21/2013	Required Date: 2/28/2013
Zong Zone	,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,					start Qty:		Required Qty: 1.00
D.4024.11		N	100	F1		-		required Qty. 1.00
D4020-11	Manufactured	No	100	Each	23.0000	2	2	0.1
D4020-11 End Mesh, Basket						**	3969	186 - N SH 13-03-1
		Location	<u>L</u>	oc Oty	Loc Code			
		WA007		- 23				
			442	2				
			972	1				
			776 553	6				
			816	2				_
			016	2				
		96	486	6				
D4021-1	Manufactured	No	100	Each	53.0000	3	3	
D4021-1 Handle Plate						**	B 88	8849 > 3x ·
• •		Location	<u>L</u>	oc Qty	Loc Code			13-02-28
		WA004		53				_
		88	323	5				—
			849	10				_
• •			204	12				
			596 597	7 4				
			039	15				_ ' '
D4034-041	Manufactured	No	100	Each	8.0000	1	1	
D4034-041 Aft Upper Rib Assembly						**	B 940	48 Sy 13.02.28
		Location	<u>L</u>	oc Qty	Loc Code			
		WA005		4				_
		84	048	1				
		92	806	3				_
		WA006		4				_
		94	048	4				_
Thursday, February 21, 2013 10):22:12 AM		Shop Packet Print					Page 5

		DQA:	Date:	,
ICD V / No	MADE ADDED NON CONFORMANCE / LIDDATE			

NCR: \	Yes / No				WORK ORDER NON-O	CON	IFORI	MANCE / UP		QA Closed:	Date:	
Work Orde	or.				DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part N	No				Rework Scrap Use-as-is Work Order Update			Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite		Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root Cause	Date	Step	Qty		ption of work order update	1	nitial ef Eng		ction cription	Sign & Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved												
						AUL	CATE	GORY				,
Landi	Cracks Crushed Cuffs Heat Tre	lot Conce /Crimped at on Strip in	-	D/S	General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes		Instruct	ion Incomplete tions Incomplete, enance eled	/Unclear	Ovalized Over/Under Part Incorre Part Lost/M Part Moved Positioned V Power Loss/	ct sissing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
	Torque \	Maves in f	Extrusion	, [Drawing	1 1	Out of	Calibration				

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Picklist Print Thursday, February 21, 2013–10:.	22:12 AM		•		Page 6
Work Order ID: 97640		*97640*			
Parent Item: D3913-041		*D3913-041*			
Parent Item Name: Long Basket E	Base Assemby, 350	17.18/1.1=(14)		Start Date: 2/21/2013 Start Qty: 1.00	Required Date: 2/28/2013 Required Qty: 1.00
D4034-043	Manufactured	No	100 Each	6.0000 1 1	
D4034-043 Fwd Upper Rib Assembly				** 39	1806
Two Oppor Rio Assembly		Location	Loc Oty	Loc Code	13-02-28
		WA005	6		
		82980	2		<u> </u>
		94042	2		<u> </u>
		94960	2		
D4672-1	Manufactured	No	100 Each	32.0000 2 2 .	•
* D4672-1 * Blanking Plate				** 3945	5/ +2x Sy,3.03-04
		Location	Loc Qty	Loc Code	
·		(WA005 '	32		
		88253	6	·	<u> </u>
•		94069 94551	13	And the second s	· · · · · · · · · · · · · · · · · · ·
M304EX0.75-16F	Purchased	94551 No	13 100 sf	726.9151 33 33	
*M304FX0 75-1				** Mia	3 448 > 33
Expanded Metal Flat 55		Location	Loc Oty	Loc Code	13-00 28
		WA	320.0000637		
		124070	0.00006372		<u> </u>
		124466	320		
		WA007	406.915		_
		122534	160		<u> </u>
		123448 124347	193.31 53.605		
		.2.3.7	55.005		

NCR:	⁄es	/ No				WORK ORDER NON-	CO	NFORM	MANCE / UPDATE				
											QA Closed:	Date:	
Work Orde	er: _					DISPOSITION	_				PARTMENT	·	1
Part N NCR N	-			, ·		Rework Scrap Use-as-is Work Order Update		Therm	~⊢	l Fab	4	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
·	•0				· · · · · · · · · · · · · · · · · · ·	Work Order opdate			zurge rus comp	O51.C	<u> </u>		اــــا
Root Cause		Date	Step	Qty	1 -	ption of work order update or Non-conformance	1	Initial hief Eng	Action Description		Sign & Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved													
			· · · · · · · · · · · · · · · · · · ·	· · · · · · · · · · · · · · · · · · ·			FAU	LT CATE	GORY				
Landi		Bending Centre No Cracks Crushed/ Cuffs Heat Trea Inspection	Crimped. It n Strip in Bend	Tube		General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes		Instruct Mainte Mislabe Misreac	on Incomplete ions Incomplete/Unclear nance iled		Ovalized Over/Under Part Incorre Part Lost/M Part Moved Positioned V Power Loss/	ct ssing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
	ľ	Torque W	aves in E	xtrusio	n	Drawing		Out of 0	Calibration				

Out of Sequence

Outside Dimensions

Date:

DQA:

Turning Sequence

Wave/Twist in Tube

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Thursday, February 21, 2013 10:22:12 AM

Parent Item Name: Long Basket Busc Assemby, 350 Start Usy:	Work Order ID: 97640 Parent Item: D3913-041			7640* 3913-041*						
ANN3-10A Bolt *ANN3-10A* Bolt **Bolt **ANN3-10A* Bolt **Bolt **ANN3-10A* Bolt **Bolt **ANN3-10A* Bolt **Bolt Parent Item Name: Long Basket Base A	Assemby, 350	. ,	.,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,						-	
Solution Loc Ote Loc Code CA STO21 STO21 STO21 STO21 STO22	AN3-10A	Purchased	No		150	Each	223.0000	6	6	
Color								**	· · · · · · · · · · · · · · · · · · ·	-86.
122800 37				Location	Lo	oc Oty	Loc Code			
ST351 98										
124221 98										-
ST512									1 10	-
AN960JD8									OX	- ,
AN960JD8							4			
Washer 102931 Manufactured No 150 Each 2,268.000 2 2 *D2931*Bumper Location Loc Otv Loc Code		Purchased	No	122800	150		0.0000	. 2	. 2	- ,
D2931	*AN960.ID8*							**	<u>^</u>	n 123900 gp
Location Loc Oty Loc Code		Manufactured	No		150	Each	2,268.000	2	2	
Location Loc Oty Loc Code									50	<u>***</u>
GA 270 46064 270 ST021 1998 86435 1998 D4021-5 Manufactured No 150 Each 29.0000 2 *D4021-5* Blanking Plate Location Loc Oty Loc Code	Bumper			I anakina	τ.	04	I C-1-		\mathcal{A}	ė.
Manufactured No 1998					L		Loc Code			water grown and
ST021 1998 86435 1998									. 77	
D4021-5 Manufactured No 150 Each 29.0000 2 2 *D4021-5* Blanking Plate Location Loc Oty Loc Code ST084 29 85065 2 88151 1									— <u></u>	<u>.</u>
D4021-5 Blanking Plate Location Loc Oty Loc Code										•
D4021-5 Blanking Plate Location Loc Otv Loc Code	D4021-5	Manufactured	No		150	Each	29.0000	2	2	
Location Loc Qty Loc Code ST084 29 85065 2 88151 1								**	Sp. 1	B-3-22.
ST084 29 85065 2 88151 1	Dianking Hate			Location	Le	ne Otv	Loc Code		•	
85065 2 <u> </u>		•			<u> 250</u>		<u> 200 godt</u>			
88151			•							
$\frac{89059}{26}$						1				•
				89059		26			-3x	•

NCR: Y	'es /	No				WORK ORDER NON-	100	NFORN	MANCE / UPDAT	E	QA Closed:	Date	
<u></u>			, *			DISPOSITION			Δ	GAINST DE	PARTMENT		•
Work Orde	er:					DISPOSITION			^			_	
			**			Rework]		Skid-tube Cr	osstube	<u>,</u>	Water Jet	Engineering
Part N	lo.	÷				Scrap		1	Machining Sr	mall Fab	Pro	d. Eng. Coor.	Quality
						Use-as-is		Therm	noforming F	inishing	Rec/Stor	re/Packaging	Other
NCR N	lo					Work Order Update]		Large Fab Co	mposite	_	Supplier	
Root					Descri	tion of work order update	T	Initial	Action		Sign &	, · · · ·	
Cause		Date	Step	Qty		or Non-conformance	1	nief Eng	Descriptio	n	Date	Verification	QC Inspector
Doc/Data	+	Dute	эсер	<u> </u>	·	31 (10) (10) (10) (10) (10) (10) (10) (10	+			· · · · · · · · · · · · · · · · · · ·			
Equip/Tooling	-						1						
Operator	\dashv												
Material	\dashv												
Setup													
Other	7												
Process	7							ļ					
Supplier												ļ	
Training													
Unapproved													
		-				F	AUI	T CATE	GORY				
Landir	ng Ge	ar				General				_			
	В	ending				Bend	L	Grain		<u> </u>	Ovalized	_	Pressure/Forced
	c	entre No	ot Conce	ntric to (o/s	BOM/Route		Hardwa	re	_	Over/Under	tolerance	Temperature/Cure
	Cı	acks				Broken/Damaged	L	Inspecti	on Incomplete		Part Incorre	}-	Weld
	Cı	rushed/	Crimped.			Burrs	L	Instruct	ions Incomplete/Uncle	ar	Part Lost/M	issing	Wrong Stock Pulled
	cı	uffs				Contamination		Mainte			Part Moved		
	Н	eat Trea	t			Countersink		Mislabe	led		Positioned \		¬
[In	spection	n Strip in	Tube		Cut Too Short		Misread	I		Power Loss/	'Surge	Other
	Ri	pples in	Bend			Drill Holes		Offset					
1 1	Tε	raue W	aves in F	xtrusio	n	Drawing	1	Out of C	Calibration				

Out of Sequence

Outside Dimensions

DQA:

Date:

Turning Sequence

Wave/Twist in Tube

Finish

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Thursday, February 21, 2013 10:22:12 AM

Work Order ID: 97640

D3913-041

Parent Item:

Parent Item Name: Long Basket Base Assemby, 350

MS20600-AD4W3

Purchased

97640 *D3913-041*

Start Date: 2/21/2013

Required Date: 2/28/2013

Required Qty: 1.00

1,379.000

Start Qty: 1.00

**

MS20600-AD4W3 Cherry Rivets

Location		Loc Qty	Loc Code	
ST311		1246		
	122151	10		
	122452	7		
	123525	329		
	124231	900		-2x
WA003		133		
	107939	133		

MS21042L3

Purchased

No

No

150

150

Each

Each

7,064.000

**

Location	Loc Oty	Loc Code	
FP001	3		
122141	3		
GA	354		
122452	354		
ST314	268		
117885	32		
119017	55		
119075	138		- 1 24mm
123265	43		
ST506	6439		
123900	2439		(ox
124291	4000		

											DQA:	Date:	
NCR:	Yes	/ No				WORK ORDER NON-C	10	NFORM	AANCE / UPDATE				
											QA Closed:	Date:	
Work Ord	or.					DISPOSITION	ì		AGAINST	DE	PARTMENT	PROCESS	
Work Ordi	er. <u>–</u>			<u>, , , , , , , , , , , , , , , , , , , </u>		Rework			Skid-tube Crosstube			Water Jet	Engineering
Part N	No.					Scrap			Machining Small Fab	-	Pro	d. Eng. Coor.	Quality
	_					Use-as-is Thermoforming Finishing				Rec/Stor	e/Packaging	Other	
NCR I	No								Large Fab Composite			Supplier	
													1
Root					1	ption of work order update	1	nitial	Action		Sign &		
Cause		Date	Step	Qty		or Non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector
Doc/Data													
Equip/Tooling													
Operator	Ш												
Material	Ш												
Setup	Ш												
Other	Ш										•		
Process	Ш								,				
Supplier	Ш												
Training	Ш												
Unapproved							<u> </u>	_			<u> </u>		
						F	AUL	T CATE	GORY				
Landi	ng Ge	ear				General		3		_	7		7
	Bending Bend							Grain		<u> </u>	Ovalized	_	Pressure/Forced
	Centre Not Concentric to O/S BOM/Route							Hardwa	re	\perp	Over/Under	-	Temperature/Cure
						Broken/Damaged		- '	on Incomplete		Part Incorre	<u> </u>	Weld
Crushed/Crimped. Burrs						Burrs	L	Instruct	ions Incomplete/Unclear	\vdash	Part Lost/Mi	ssing	Wrong Stock Pulled
	Cuffs Contamination						Maintenance				Part Moved		
	Heat Treat Countersink						Mislabeled				Positioned Wrong		_
	Inspection Strip in Tube Cut Too Short						Misread Power Loss/Surge					Surge	Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish Folio

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Thursday, February 21, 2013 10:22:12 AM

Work Order ID: 97640

Parent Item:

D3913-041

Parent Item Name: Long Basket Base Assemby, 350

NAS1149F0332P

Purchased

D3913-041

97640

Start Date: 2/21/2013

Required Date: 2/28/2013

Start Qty: 1.00

Required Qty: 1.00

NAS1149F0332P

No

150

Each

10,560.00

12

12

**

Location	Loc Oty	Loc Code	
GA	194		
122063	194		
ST294	363		
122063	363		
ST295	3		
123352	3		
st510	10000		
123900	10000		-/2x

NCR:	Yes	/ No				WORK ORDER NON-	COI	NFORM	AANCE / UPDATE		OA Classed	Da	+ 0 ·	
						<u> </u>		r -			QA Closed:	Da	te:	
Work Orde	er:					DISPOSITION	,		AGAINST	DE	PARTMENT	/PROCESS		
Part N	_					Rework Scrap Use-as-is		Skid-tube Crosstube Machining Small Fab Thermoforming Finishing				Water Jet d. Eng. Coor e/Packaging		Engineering Quality Other
NCR N	No					Work Order Update Large Fab Composite]	Supplier			
Root					Descri	ption of work order update		Initial	Action		Sign &			
Cause		Date	Step	Qty	(or Non-conformance	Cł	nief Eng	Description		Date	Verificatio	n	QC Inspector
Doc/Data								•					j	
Equip/Tooling														
Operator														
Material														
Setup														
Other														
Process														
Supplier														
Training														
Unapproved														
						F	AUI	T CATE	GORY					
Landi	ng Ge	ar				General	,	_		_	_			
	В	ending				Bend		Grain			Ovalized			Pressure/Forced
	Щc	entre No	t Concer	ntric to (D/S	BOM/Route		Hardwa	re		Over/Under	tolerance	Ш	Temperature/Cure
		racks				Broken/Damaged	L	Inspecti	on Incomplete	L	Part Incorre	ct		Weld
		rushed/0	Crimped.			Burrs	L	Instruct	ions Incomplete/Unclear	L	Part Lost/M	ssing		Wrong Stock Pulled
		uffs				Contamination		Mainte	nance		Part Moved			
	\square H	eat Trea	t			Countersink		Mislabe	led		Positioned V	Vrong		•
	lr	spection	Strip in	Tube		Cut Too Short		Misread	l		Power Loss/	Surge		Other
Ripples in Bend Drill Holes						Drill Holes		Offset						
ľ	7	oraua M	avec in E	vtrucion	、	Drawing		Out of C	alibration					

Out of Sequence

Outside Dimensions

DQA:

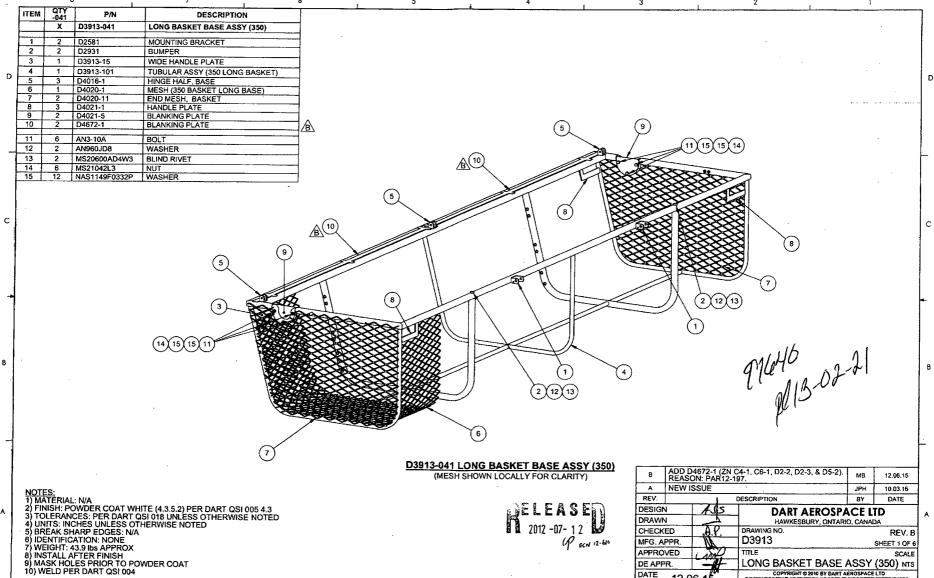
Date:

Turning Sequence

Wave/Twist in Tube

Finish

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DATE

12.06.15

NCR:	Yes	/ No				WORK ORDER NON-	100	NFORM	ANCE / UP	DATE		•			
	-											QA Closed:	Da	ite:	
Work Ord	or.					DISPOSITION				AGAINST D	ÞΕ	PARTMENT,	PROCESS		
Part I						Rework Scrap	1	Skid-tube Crosstube Machining Small Fab Thermoforming Finishing			Waiter Prod. Eng. Co Rec/Store/Packag			Engineering Quality Other	
NCR No.						1 <u>—</u> 1			Large Fab					Other	
Root					Descri	ption of work order update		Initial	Act	tion		Sign &			
Cause		Date	Step	Qty	(or Non-conformance	Ch	nief Eng	Desci	ription		Date	Verificatio	n	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other															·
Process				·											
Supplier Training Unapproved															
			•	<u> </u>		F	AUL	T CATE	GORY						
Landi	ng (Gear				General		_		_		_		_	_
	Bending Centre Not Concentric to O/S					Bend BOM/Route		Grain Hardwa	re	-		Ovalized Over/Under	tolerance		Pressure/Forced Temperature/Cure
	Cracks					Broken/Damaged		Inspecti	on Incomplete			Part Incorre	ct		Weld
Crushed/Crimped.				Burrs		Instruct	ions Incomplete/	Unclear		Part Lost/M	issing		Wrong Stock Pulled		
Cuffs				Contamination		Mainte	nance			Part Moved					
		Heat Trea	ıt			Countersink		Mislabe	led			Positioned V	Vrong	_	-
Inspection Strip in Tube						Cut Too Short	Misread Po			Power Loss/	Surge	L	Other		
Rinspection Strip in Tube					<u> </u>	Drill Holes		Offset							

Out of Calibration

Out of Sequence

Outside Dimensions

DQA:

Date:

Turning Sequence

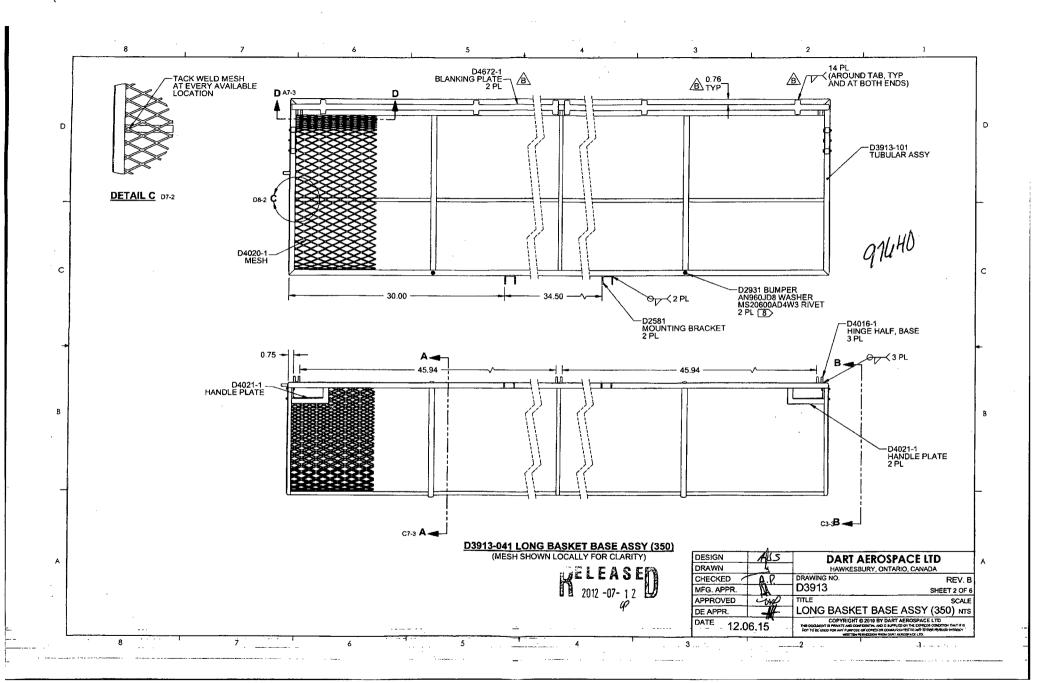
Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G



NCR:	Yes	/ No				WORK ORDER NON-C	100	NFORN	MANCE / UPI	DATE	QA Closed:	Date	·
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Part No						Scrap Mach Use-as-is Thermofor			Skid-tube Machining noforming Large Fab	Crosstube Water Jet Engine Small Fab Prod. Eng. Coor. Qu Finishing Rec/Store/Packaging Composite Supplier			
Root					Descri	ption of work order update	ı	nitial	Act	ion	Sign &		
Cause		Date	Step	Qty	,	or Non-conformance	Ch	ief Eng	Descr	iption	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved													
						F.	AUL	T CATE	GORY				
Landii	Bending Centre Not Concentric to O/S Cracks Crushed/Crimped. Cuffs Heat Treat Inspection Strip in Tube Ripples in Bend				O/S	General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes		1	on Incomplete ions Incomplete/U nance led	Jnclear	Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	ct issing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other

Out of Calibration

Out of Sequence

Outside Dimensions

DQA:

Date:

Turning Sequence

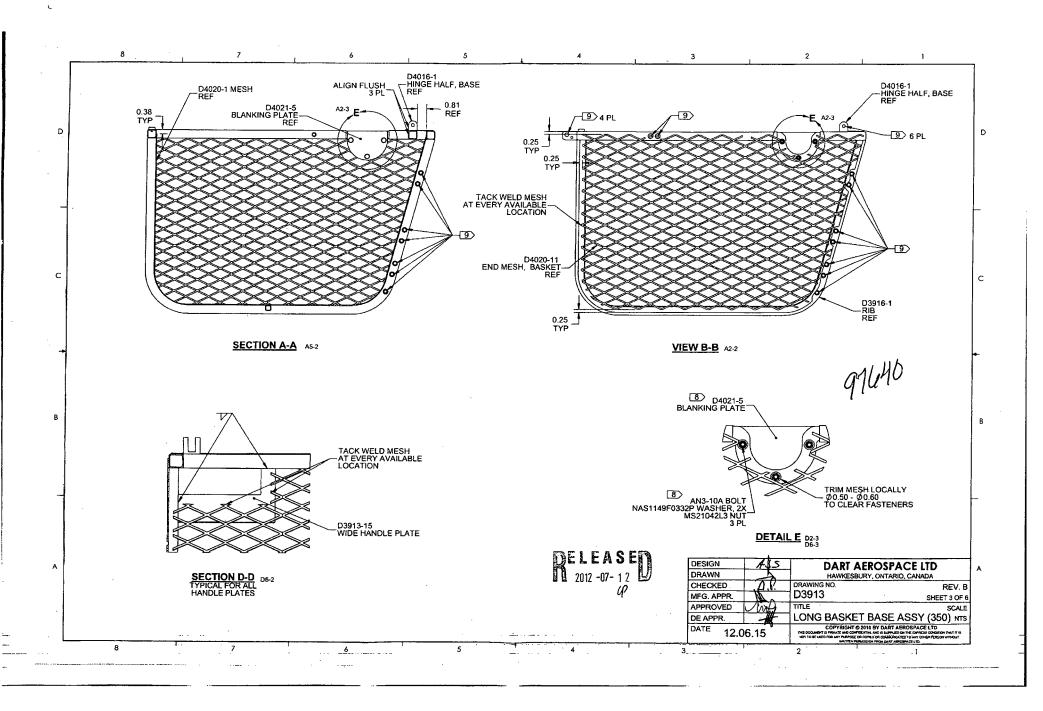
Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G



											DQA:	Date:	
NCR:	Yes /	No				WORK ORDER NON-C	CONF	FORN	MANCE / UPI		QA Closed:	Date:	
· · · · · ·						<u> </u>					QA Closed.	Date.	
Work Orde	or.					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Work Orac	··· ——			 -		Rework	1		Skid-tube	Crosstube		Water Jet	Engineering
Part N	No.					Scrap	1 1		Machining	Small Fab	Pro	d. Eng. Coor.	Quality
						Use-as-is	1	Therm	noforming	Finishing	Rec/Sto	re/Packaging	Other
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Equip/Tooling													
Operator													
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		nding				Bend		irain		ļ	Ovalized	<u> </u>	Pressure/Forced
	⊢		t Conce	ntric to	0/s	BOM/Route	\vdash	lardwa			Over/Under	<u> </u>	Temperature/Cure
	Cra					Broken/Damaged	 	•	on Incomplete		Part Incorre		Weld
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	Cuf					Contamination			nance		Part Moved		
	_	at Trea			<u> </u>	Countersink	-	∕iislabe		 	Positioned \		٦٠٠٠
			Strip in	Tube		Cut Too Short	\vdash	⁄lisread	1	L_	Power Loss/	Surge	Other
ļ		ples in				Drill Holes	\mathbf{H}^{-1}	Offset					
	ITor	nue W.	aves in F	ytrusio	n I	Drawing	1 10	of C	alibration				

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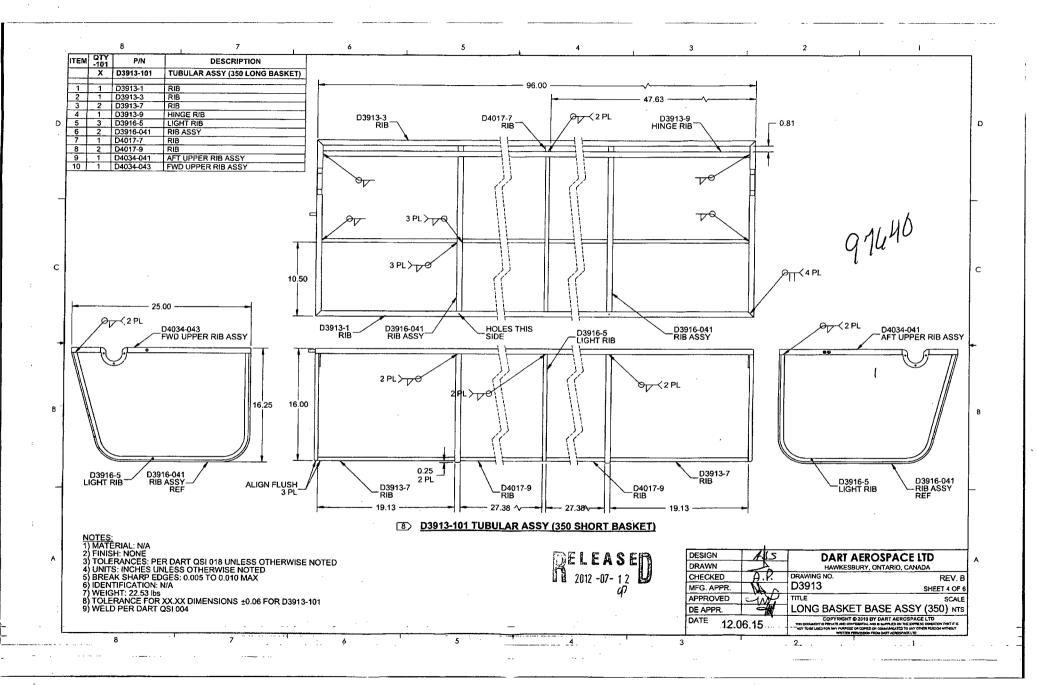
Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Finish

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NCR:	Yes	/ No				WORK ORDER NON-C	100	VFORM	MANCE / UPI	DATE		•		_	-
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	Bending Centre Not Concentric to O/S Cracks Crushed/Crimped. Cuffs Heat Treat Inspection Strip in Tube				o/s	Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short		Grain Hardware Inspection Incomplete Instructions Incomplete/Unclear Maintenance Mislabeled Misread				Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	ct [issing [Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
Ripples in Bend Drill Holes Offset															

Out of Calibration

Out of Sequence

Outside Dimensions

DQA:

Date:

Turning Sequence

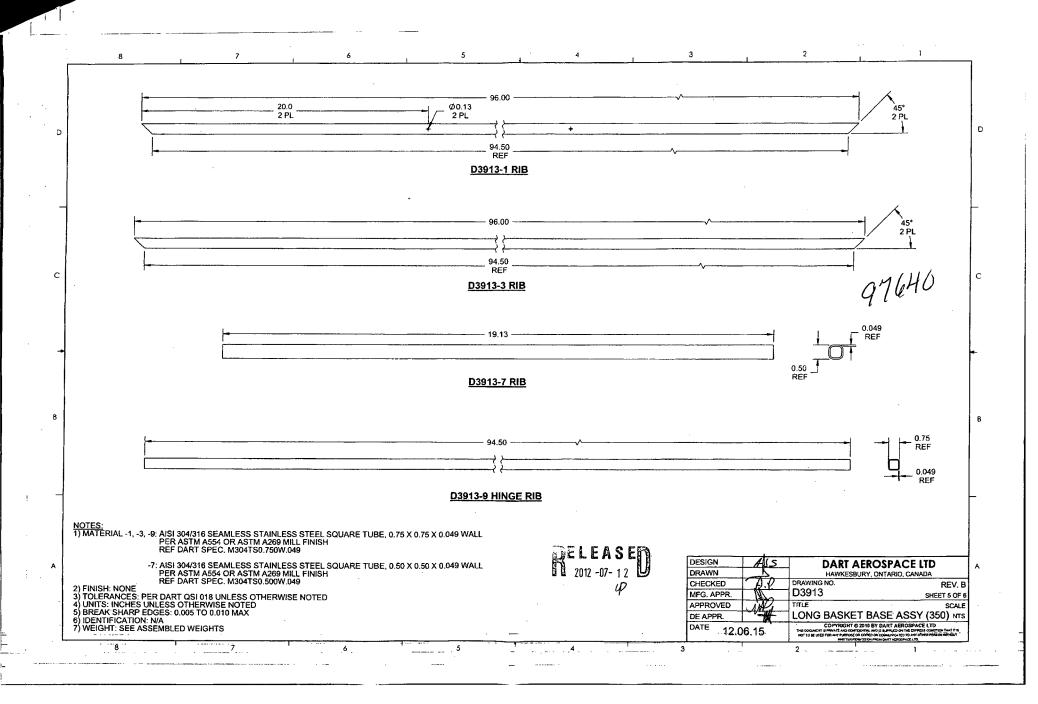
Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

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NCR: Y	es / No		•		WORK ORDER NON-	CONFO)RN	MANCE / UPDATE				• •
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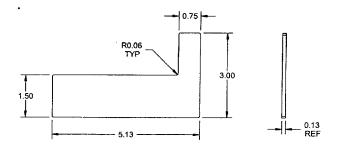
Outside Dimensions

DQA:

Date:

Wave/Twist in Tube

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G



D3913-15 WIDE HANDLE PLATE

NOTES:
1) MATERIAL: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 REFOART SPEC M304S11GA
2) FINISH: NONE
3) TOLERANCES: PER DART OSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.31 lbs

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DESIGN	1	5	DART AEROSPA	CELID
DRAWN		5_	HAWKESBURY, ONTARIO	
CHECKED	A	V.	DRAWING NO.	REV. B
MFG. APPR.		<u> </u>	7D3913	SHEET 6 OF 6
APPROVED	1	NE.	TITLE	SCALE
DE APPR.	-	U -	LONG BASKET BASE A	SSY (350) NTS
DATE . 12.0	6.15	-	COPYRIGHT © 2010 BY DART AE THIS DOCUMENT IS PROVITE AND COMPOSITIVE, AND IS SUPPLIED OF MOT TO BE LISED FOR ANY PUMPOSE OR COPED OR COMMUNICATION.	THE COMESS CONDITION THAT IT IS

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	Cracks	;			Broken/Damaged		Inspect	ion Incomplete	•	Part Incorre	ct	Weld
.,	Crush	ed/Crimped			Burrs		Instruct	tions Incomplete	e/Unclear	Part Lost/M	issing	Wrong Stock Pulled
	Cuffs		•		Contamination .	•	Mainte	enance	÷	Part Moved		
		roat		[Countersink		Mislahe	aled		Positioned \	Nrong	

Misread

Out of Calibration

Out of Sequence

Outside Dimensions

Offset

Power Loss/Surge

Other

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Inspection Strip in Tube

Torque Waves in Extrusion

Cut Too Short

Drill Holes

Drawing

Finish Folio